

Date: Thursday, 11/12/2008 10:44:54 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RIB ASSY (BASKET LID, LH)
Job Number	: 44018		
Estimate Number	: 13662		
P.O. Number	:	Part Number	: D3836041
This Issue	: 11/12/2008 S.O. No. :	Drawing Number	: D3836 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 22/12/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>JLD 08.12.11</u>		
Comment	: Est Rev:A 08-12-01 new issue DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D23273	Spacer Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

✓ Spacer Bushing

Batch: B39560

SY 09/01/06

2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 1.8698 f(s)/Unit Total: 7.4794 f(s)

304 SQ Tube .75x.75x.065W

batch: M110011

SAD 08-12-29 (9)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- cut D3836-1 and D3836-3 rib as per dwg D3836

2- drill hole in D3836-1 as per dwg D3836 using DT9436 jig

3- remove identification markings

4- deburr

SAD 08-12-29

SAD 08-12-29

SAD 08-12-29

SAD 08-12-29 (9)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/01/05 (74)

(P70)

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- weld D3836-1 to D3836-3 as per dwg D3836 using DT9447 welding jig

\*\*\*\*after welding ensure measurements are good\*\*\*\*

2- weld D2327-3 spacer bushing as per dwg D3836

SY 09/01/06 (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3836-041 PAR #: N/A Fault Category: Prod/PAB LG NCR: (Yes) No DQA: D Date: 09/01/05  
 Resolution: D3836-041 / D3836-607-043 Disposition:  QA: N/C Closed: AD Date: 09/01/05

NCR: <u>4408</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-12-30</u>	<u>3.0</u>	<u>Qty 4x D3836-1 ribs were cut as -2's.</u>  <u>R.C: Lack of attention to chug detail</u>	<u>[Signature]</u> <u>08/12/05</u>	<u>parts will be used on D3836-042 B110019 W/O, for a total of 8.</u> <u>Replace the Qty 4 - 1's on this W/O B# B110011</u> <u>Ensure to correctly read &amp; understand the chug before cutting</u>	<u>[Signature]</u> <u>08-12-30</u>	<u>[Signature]</u> <u>09/01/05</u>	<u>[Signature]</u> <u>08/12/30</u>	

NOTE: Date & initial all entries

Date: Thursday, 11/12/2008 10:44:55 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET LID, LH)

Job Number: 44018

Part Number: D3836041

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R ER316 S.S. Rod Batch: 4108775

3- grind weld flush where indicated on dwg D3836

4- deburr if necessary

*sd* 09/01/06 (4x)

6.0

QC9

VISUAL WELDING INSPECTION



(4)

Comment: VISUAL WELDING INSPECTION

*sd* 09-01-06

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*sd* 09/01/06 (4x)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BASKET CELL

*sd* 09/01/06

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

*sd* 09/01/07  
*MF* 09-01-07

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

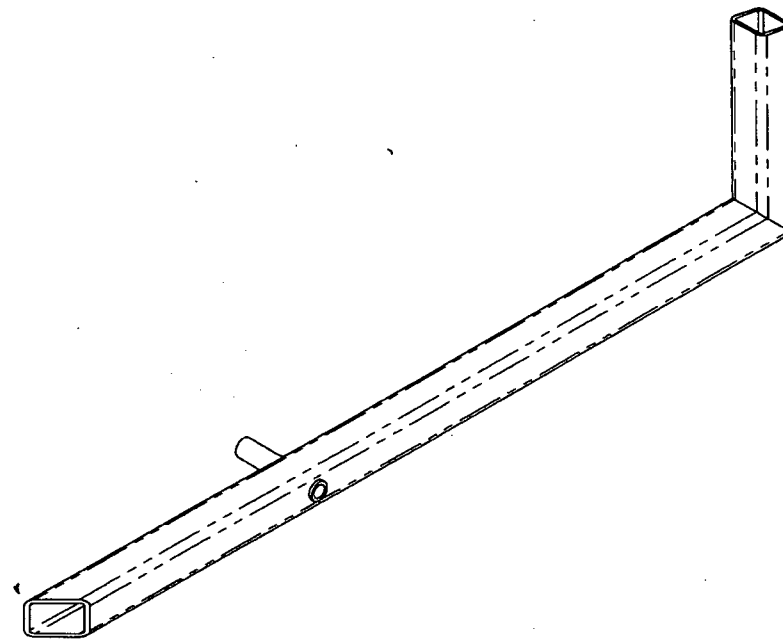
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

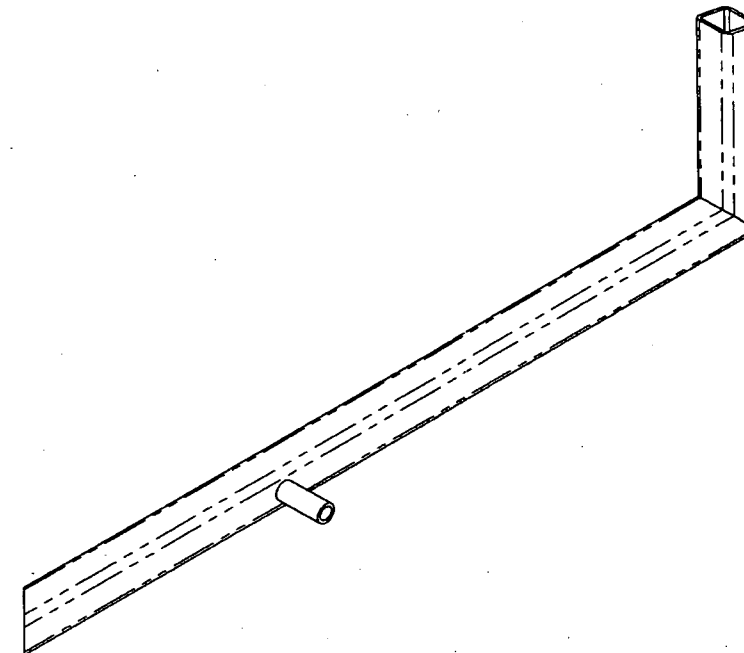
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB



**D3836-042 RIB ASSY (BASKET LID, RH)**



**D3836-041 RIB ASSY (BASKET LID, LH)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs EACH
- 8) WELD PER DART QSI 004

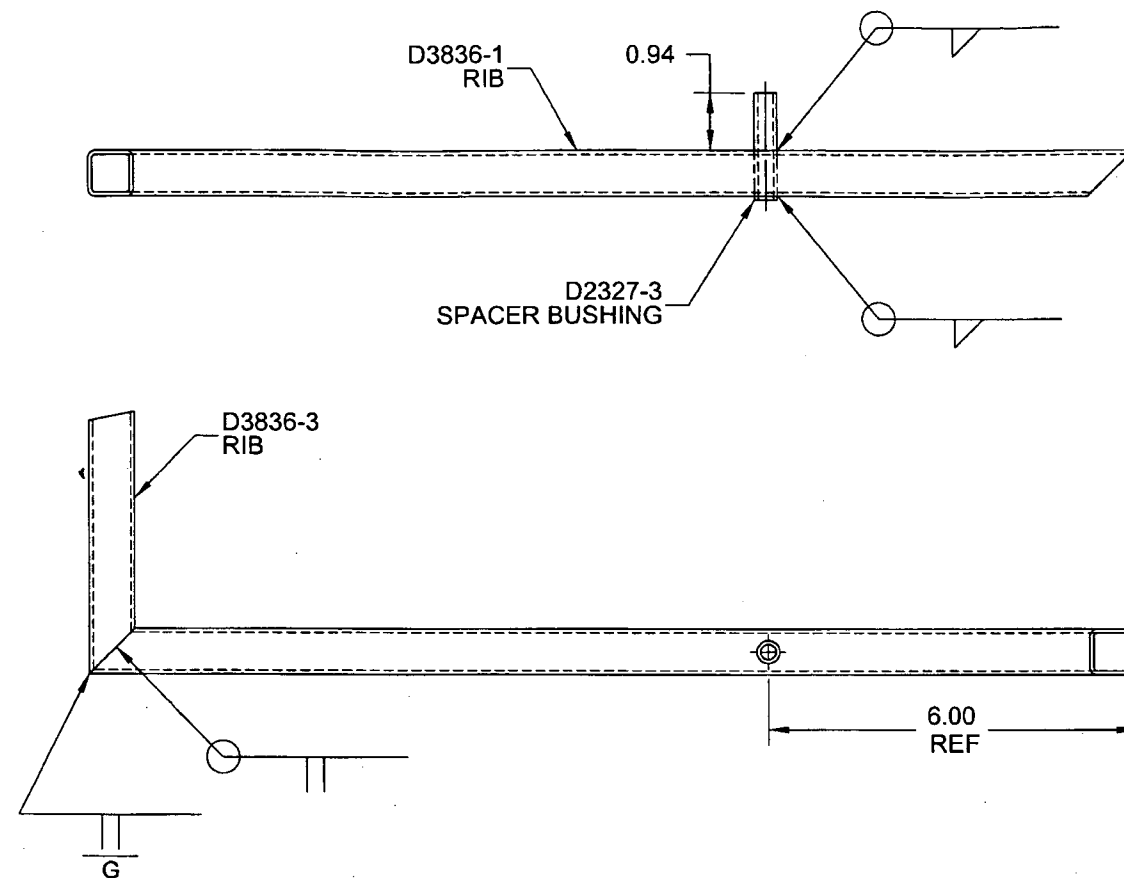
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WORK ORDER  
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**RELEASED**  
08/11/12 MB

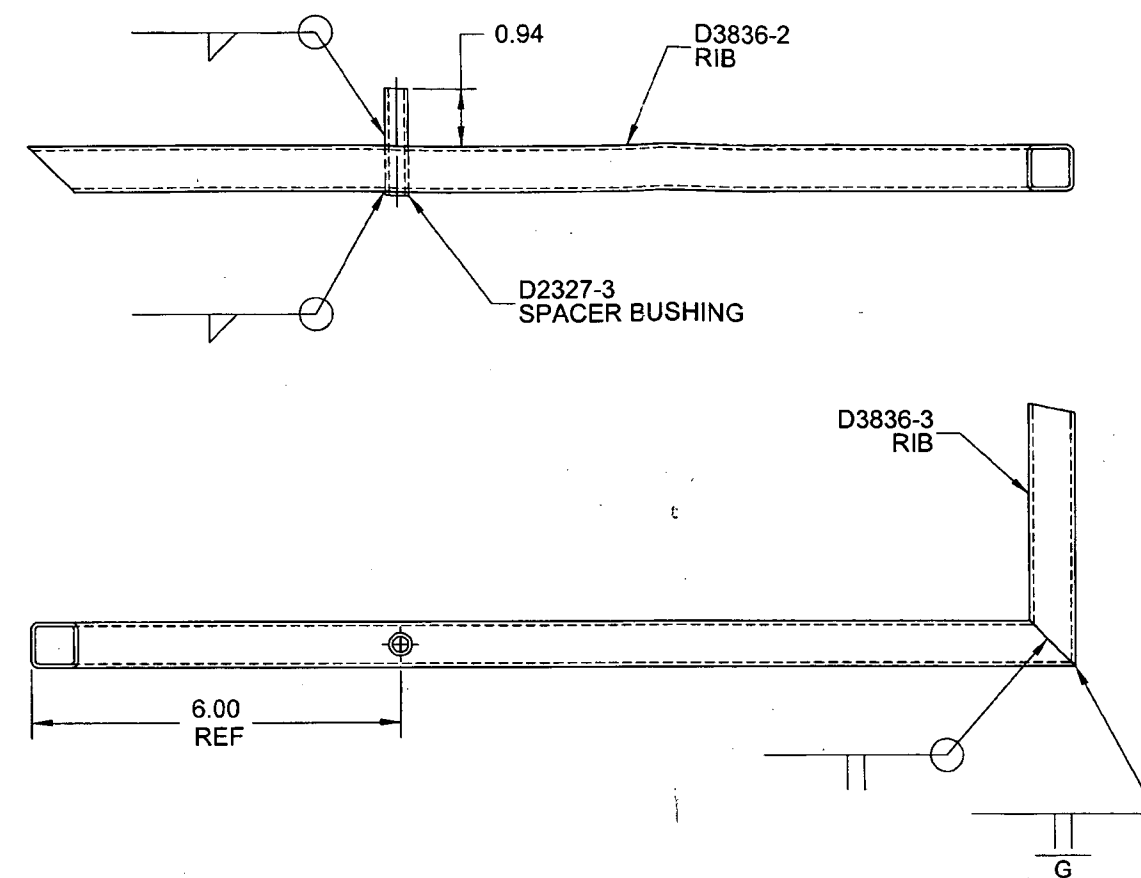
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REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3836</b>	REV. A SHEET 1 OF 3
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**D3836-041 RIB ASSY (BASKET LID, LH)**



**D3836-042 RIB ASSY (BASKET LID, RH)**

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WORK ORDER

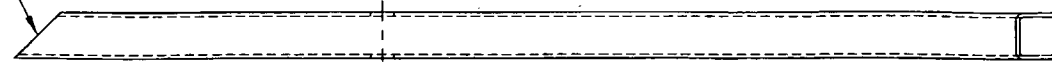
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08/11/18

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
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CHECKED	<i>BS</i>	DRAWING NO. REV. A
MFG. APPR.	<i>BS</i>	D3836 SHEET 2 OF
APPROVED	<i>BS</i>	TITLE SCAL
DE APPR.	<i>BS</i>	RIB ASSY (BASKET LID) NT
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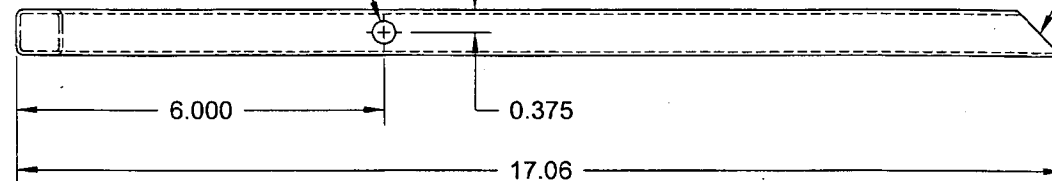




0.75 X 45°  
CHAMFER



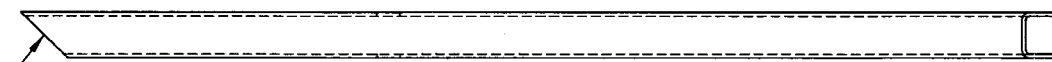
$\varnothing 0.375^{+0.020}_{-0.000}$  THRU



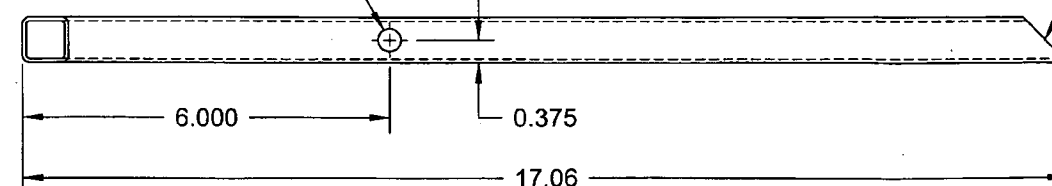
0.75 X 45°  
CHAMFER

**D3836-1 RIB**

0.75 X 45°  
CHAMFER

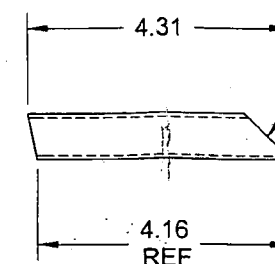


$\varnothing 0.375^{+0.020}_{-0.000}$  THRU



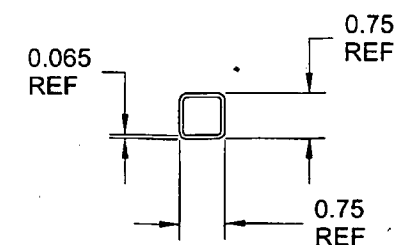
0.75 X 45°  
CHAMFER

**D3836-2 RIB**



0.75 X 45°  
CHAMFER

**D3836-3 RIB**



**TYPICAL SECTION  
VIEW**

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WORK ORDER  
NO. 4408

**RELEASED**  
08/11/18

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.75W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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